

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021710**Date Inspected:** 23-Feb-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Kelly Leavitt, was present during the times noted above for random observations relative to the work being performed.

Bay 14

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Flux Core Arc Welding (FCAW) process.

ZPMC QC is identified as Zhan Hai Feng CWI QA Bao Qiam.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Components; OBG 14E

PCMK: SA3208-001

Weld No: 001

Welder: 020009

WPS-B-T-2232-ESAB

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Zhan Hai Feng CWI QA Bao Qiam.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

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Components; OBG 14E
PCMK: DP3160-001
Weld No: 003
Welder: 067656
Repair No. WR20249
WPS-345-SMAW-2G(2F)-FMC-Repair-1

Components; OBG 14E
PCMK: DP3160-001
Weld No: 003
Welder: 037932
Repair No. WR20249
WPS-345-SMAW-2G(2F)-FMC-Repair-1

Components; OBG 14E
PCMK: DP3160-001
Weld No: 005
Welder: 215553
Repair No. WR20249
WPS-345-SMAW-2G(2F)-FMC-Repair-1

Components; OBG 14E
PCMK: SEG3019BB
Weld No: 157
Welder: 066418
Repair No. WR20270
WPS-345-SMAW-3G(3F)-FMC-Repair-1

Components; OBG 14E (see photo below)
PCMK: SEG3019BB
Weld No: 051
Welder: 067610
WPS-B-P-2114-FCM-1

Components; OBG
PCMK: SEG3007N
Weld No: 148,153
Welder: 068924
WPS-B-P-2213-TC-U4b-FCM-1

Components; OBG
PCMK: SEG3007M
Weld No: 106

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Welder: 037743

Repair No. B-WR19316

WPS-345-SMAW-3G(3F)-FCM-Repair-1

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Li Ping, CWI An Qing Xiang.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Components; OBG

PCMK: DP3172-001

Weld No: 019

Welder: 066038

WPS-B-P-2212-TC-U4b-FCM-1

Components; OBG

PCMK: DP3172-001

Weld No: 020

Welder: 066480

WPS-B-P-2212-TC-U4b-FCM-1

Components; OBG

PCMK: DP3172-001

Weld No: 018

Welder: 037780

WPS-B-P-2212-TC-U4b-FCM-1

Components; OBG PP126~126.5

PCMK: SEG3020R

Weld No: 024,026

Welder: 067764

WPS-B-P-2114-FCM-1

Components; OBG PP126~126.5

PCMK: SEG3020P

Weld No: 023,028

Welder: 067764

WPS-B-P-2114-FCM-1

Components; OBG PP126~126.5

PCMK: SEG3020R

Weld No: 028,030

Welder: 067069

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WPS-B-P-2114-FCM-1

Components; OBG PP126~126.5

PCMK: SEG3020P

Weld No: 030,051

Welder: 067069

WPS-B-P-2114-FCM-1

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Flux Core Arc Welding (FCAW) process.

ZPMC QC is identified as Li Ping, CWI An Qing Xiang.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Components; OBG

PCMK: SEG3020BB

Weld No: 113

Welder: 067949

WPS-B-T-2233-ESAB

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No significant conversations

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey 1500026784, who represents the Office of Structural Materials for your project.

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Inspected By: Leavitt,Kelly

Quality Assurance Inspector

Reviewed By: Riley,Ken

QA Reviewer